

55114 Derev

Work Order ID 53185

October 26, 2009 10:45:59 AM

Page 1

Item ID: D350-600-242

Accept

Setup Start

Revision ID: C

Stop

Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09 Start Qty: 1.00

Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

S 10/01/04

HJ fa BG 09/10/27

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971
 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
 3-Deburr
 4-Install inserts in D3188-2 as per Dwg D3188.

Z 09-1229

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10512-30

Work Order ID 53185

October 26, 2009 10:46:00 AM



Page 2

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1-Cut D2986 Neoprene Foam per template D2986T1 2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive A/R Batch: <u>112983</u>	0.00	N/A see w/o 54847			RT 09-1229			
140 Small Fab	Small Fab	0.00							
Small Fab	Memo ****This step seperates hardware, previous steps is for body & floor****	0.00							

Work Order ID 53185

October 26, 2009 10:46:05 AM



Page 3

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

0.00



Small Fab

Small Fab

Memo

0.00

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: 113022 expire date: 10-9-18

A/R Milled fibres batch: 11100859

2- Prime (grey) as necessary per QSI005

Primer batch: 112384

Hardner batch: 112960

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: 112983

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

QC5

Memo

0.00

25 09-12-29

PTO

10-12-30

PTO

W/O: 53185		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-12-29	160	QC 3 should be QC 5, to inspect the drilling, cutting etc. Remove QC 3 perm change	JA	10/01/06		05-12-29	05-12-29

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 53185		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-28	150	MS20426 AD4-5 Rivets too long did not crush properly tried to install 2x did not work Bent D 2237 upon removal (striker plate)	MS/WK2	install shorter rivets MS20426 AD4-4 M15541 scrap + replace striker brackets plates B 52327	RT 09-12-28	05-12-28	MS/WK2	05-12-28
		R.C. Process: timing variation in flange thickness						

NOTE: Date & initial all entries

Work Order ID 53185

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Start Date: 10/26/09 Start Qty: 1.00

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Required Date: 11/06/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

0512-30

180

Wing Walk as per dwg QSI005 4.4 Batch 112623 0.00



HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

2109 - 02 - 30

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

bf 0001-4 0

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Page 5

Item ID: D350-600-242

Accept

Setup Start

Revision ID: C

Stop

Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09 Start Qty: 1.00

Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/27 DSO

210

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 5 10/01/04

41

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-242

Location:

PPP Rev: B

10-1-5 DSO

Work Order ID 53185

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Page 6

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

W 10.06.05

Picklist Print

October 26, 2009 10:45:04 AM

Page 1

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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ALS4-1032-130		Purchased	No			110	Each	5,265.000	28.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

5265

110511

5265

D3015-3RevB

Manufactured No

130

Each

328.0000

1.0000



Locknut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

128

43758

26

44446

49

48238

53

Main Warehouse

ST59

200

51711

200

110511 sf

48238 9/10/27 (12) sf

Picklist Print

Page 2

October 26, 2009 10:45:04 AM

Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R24		Purchased	No			140	Each	116.0000	4.0000			



screw



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

116

104603

20

110179

96

100/79 9/10/27 RSP

Picklist Print

October 26, 2009 10:45:04 AM

Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			140	Each	1,579.000	1.0000			



Washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1579	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	165	
112828	500	

112794 9/10/27 @ SP

Picklist Print

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Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355



Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 		Purchased	No			140	Each	1,685.000	4.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1685	
107091	9	
108335	11	
110382	48	
110917	3	
111578	314	
112314	500	
112385	800	

111578 SP

D2179RevB

Manufactured No

140 Each 81.0000 2.0000



Doubler

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	81	
35432	81	

35432 9/10/27 @ SP

Picklist Print

October 26, 2009 10:45:05 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237RevD1  Striker Plate		Manufactured	No			140	Each	77.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5

46162 5

Main Warehouse

ST022 72

50348 17

52327 55

D2986RevB *M-4111N-5, 125 ~~2986~~ 2986* Manufactured No



Black Neoprene Foam .125

D3538-1RevA Manufactured No



Hinge Bracket

354847

~~M12333~~

50348 SF

25 09-12-29

48197 9/10/27 DSY

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 14

48197 14

Main Warehouse

ST111 10

50336 10

Picklist Print

October 26, 2009 10:45:06 AM

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Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Comments:

Start Date: 10/26/09

Required Date: 11/06/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3554-7RevA  Ball Stud		Manufactured	No			140	Each	60.0000	1.0000			


37674 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
37674	60	

D3567-2RevA  Decal		Manufactured	No			140	Each	29.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
39678	10	
50375	19	

39678 SP

MS20426AD4-5  Rivet		Purchased	No			140	Each	7,910.000	4.0000			
--	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--

6733 9/10/24 KES

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7910	
4067	1097	
6733	1831	
6874	4982	

October 26, 2009 10:45:06 AM

Shop Packet Print

Page 6

Picklist Print

October 26, 2009 10:45:07 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C832R10		Purchased	No			150	Each	105.0000	8.0000			
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Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105

104603

105

AN526C832R14		Purchased	No			150	Each	937.0000	2.0000			
--------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

937

104916

937

104603 *SL*

104916 9/10/27 *KS*

Picklist Print

October 26, 2009 10:45:07 AM

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Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Comments:

Start Date: 10/26/09

Required Date: 11/06/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10

Purchased

No

150

Each

1,881.000

2.0000



Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1881

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

1000

112369

490

112369

54

AN960JD8

Purchased

No

150

Each

1,685.000

16.0000



Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1685

107091

9

108335

11

110382

48

110917

3

111578

314

112314

500

112385

800

111578

9/10/27 10g

October 26, 2009 10:45:07 AM

Shop Packet Print

Page 8

Picklist Print

October 26, 2009 10:45:20 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2228RevB  Bracket Plate		Manufactured	No			150	Each	80.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 80

30679 37

48228 43

D2464RevB

Manufactured No

150 f

770.9610 11.3684



3/4 Seal

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 770.9609737

39669 89.87

48173 681.090974

30679 54

RT 09-12-29

343173

Picklist Print

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Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2585RevB

Manufactured

No

150

Each

47.0000

2.0000



Mounting Channel



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

43

50544

4

51526

39

50544 SD

D2586RevD

Manufactured

No

150

Each

107.0000

2.0000



Door Latch



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

107

23082

0

45554

1

47183

6

50213

100

47183

9/10/27 @ SD

Picklist Print

October 26, 2009 10:45:25 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355




Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2621RevB  Latch Plate, 350 Spacepod		Manufactured	No			150	Each	68.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46842</div> </div> <div> <div>Loc Qty</div> <div>68</div> <div>68</div> </div> <div> <div>Loc Code</div> </div>												
D2857-1RevB  Hinge Bracket		Manufactured	No			150	Each	18.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>41166</div> <div>45788</div> <div>50235</div> </div> <div> <div>Loc Qty</div> <div>18</div> <div>7</div> <div>5</div> <div>6</div> </div> <div> <div>Loc Code</div> </div>												
D2857-2RevB  Hinge Bracket		Manufactured	No			150	Each	14.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>45797</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>14</div> </div> <div> <div>Loc Code</div> </div>												

46842 SF

45788 SF

45797 9/10/27 R2 SF

Picklist Print

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Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3557-1RevA

Manufactured

No

150

Each

23.0000

1.0000



Bracket

46887 sp

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

32647

1

46887

7

50283

15

D3567-2RevA

Manufactured

No

150

Each

29.0000

1.0000



Decal

N/A

on who
twice
see pg. 6 of BOM

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

39678

10

50375

19

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Shop Packet Print

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Picklist Print

October 26, 2009 10:45:31 AM

Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No			150	Each	407.0000	18.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	407
110002	24
111889	51
112243	47
112492	85
112612	100
112794	100

112792 50

MS21042L3

Purchased

No

150

Each

3,409.000

2.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3409
110844	32
111274	35
111668	842
112314	2000
112385	500

111668 9/10/27 50

Picklist Print

October 26, 2009 10:45:31 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11		Purchased	No			150	Each	78.0000	2.0000			
												
Screw												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

78

111977

78

111977 SD

MS27039-1-15 Purchased

No

150

Each

180.0000

2.0000



Screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

180

106903

3

108169

4

109321

4

111916

69

112794

100

111916 9/10/27 RD SD

Picklist Print

October 26, 2009 10:45:36 AM

Page 15

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Comments:

Start Date: 10/26/09

Required Date: 11/06/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3  Washer		Purchased	No			150	Each	490.0000	2.0000			

111268

SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

490

109268

259

110397

87

111268

144

AN526C832R10

Purchased

No

200

Each

105.0000

2.0000

Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

105

104603

105

104603

9/10/24 @ SP

October 26, 2009 10:45:36 AM

Shop Packet Print

Page 15

Picklist Print

October 26, 2009 10:45:37 AM

Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			200	Each	1,579.000	2.0000			



Washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1579	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	165	
112828	500	

112794 9/10/27
E

Picklist Print

October 26, 2009 10:45:42 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8  Washer		Purchased	No			200	Each	1,685.000	12.0000			

instaler

Warehouse
Location

Main Warehouse

Loc Qty	Loc Code
ST	1685
107091	9
108335	11
110382	48
110917	3
111578	314
112314	500
112385	800

111578

SP

D2985RevA1

Manufactured No

200

Each

19.0000

1.0000



Label

instaler

Warehouse
Location

Main Warehouse

Loc Qty	Loc Code
ST	19
48236	9
50232	10

48236

9/10/27

SP

Picklist Print

October 26, 2009 10:45:42 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D350-600-449RevC

Manufactured

No

200

Each

5.0000

1.0000



Switch Relocation

47203 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

5

47203

1

50244

4

D3547-1RevA

Manufactured

No

200

Each

22.0000

1.0000



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

35455

8

50260

14

35455 SP

D3550-1RevB

Manufactured

No

200

Each

17.0000

1.0000



Strut

48367 9/10/27 QSP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

48367

17

Picklist Print

October 26, 2009 10:45:48 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D3552-7RevD



Door Prop

Manufactured

No

200

Each

12.0000

1.0000



52451

SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

52451

12

S D3554-7RevA



Ball Stud

Manufactured

No

200

Each

60.0000

1.0000



37674 SG

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

37674

60

S K10021RevN/A



Spacepod Hardware Kit (-241)

Manufactured

No

200

Each

3.0000

1.0000



50276 P/10/20/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

3

41361

1

50276

2

Picklist Print

October 26, 2009 10:45:48 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Comments:

Start Date: 10/26/09

Required Date: 11/06/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08

Purchased

No

200

Each

407.0000

44.0000



Nut

102492 \$

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

407

110002

24

111889

51

112243

47

112492

85

112612

100

112794

100

D3188-2MRevE

Manufactured

No

110

Each

1.0000

1.0000



SPACEPOD BODY RH

RT 09-12-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

1

46180A

1

D3186-4RevE

Manufactured

No

110

Each

0.0000

1.0000



Spacepod Door, RH

RT 09-12-21

B53191

Picklist Print

October 26, 2009 10:45:53 AM

Work Order ID: 53185

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3187-2RevC		Manufactured	No			110	Each	5.0000	1.0000			
												
Spacepod Floor												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

31836

5

A3235-020-935

Purchased

No

110

Each

694.0000

8.0000



Washer - Countersunk

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

694

104156

3

106150

691

31832 SP

106150 9/10/27 SP
(x)

Picklist Print

October, 26, 2009 10:45:54 AM

Work Order ID: 53185



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 10/26/09

Required Date: 11/06/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB		Manufactured	No			200	Each	328.0000	1.0000			



Locknut



48238 9/10/27 10 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	128	
43758	26	
44446	49	
48238	53	
Main Warehouse		
ST59	200	
51711	200	

DART

RELEASED

07.04.09

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB	DRAWING NO.	REV. E
Ce	AK	D3188	SHEET 1 OF 11
DATE	TITLE	SCALE	
07.04.02	SPACEPOD BODY	NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART
D3188-1M/-1/-5
D3188-2M/-2/-6
D3188-3M/-3/-7

LAYUP
DT8003
DT8004
DT8500

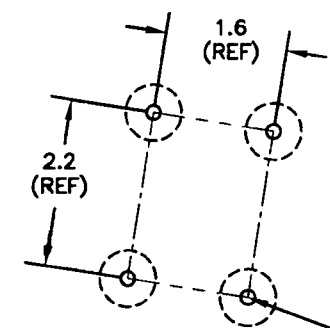
TRIM AND DRILL
DT8501
DT8502
DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

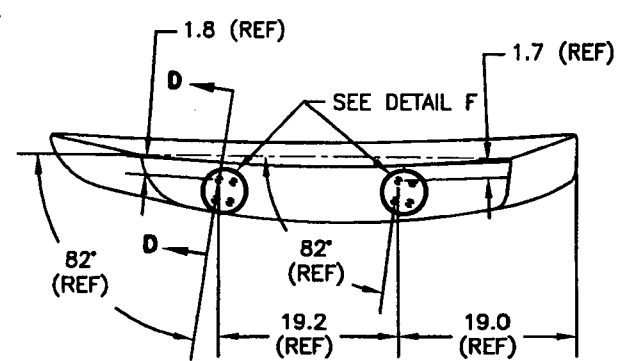
RELEASED
07.04.02

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CHECKED	CE	APPROVED	CE	DRAWING NO.	D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET	2 OF 11
		SCALE	NTS	REV.	E

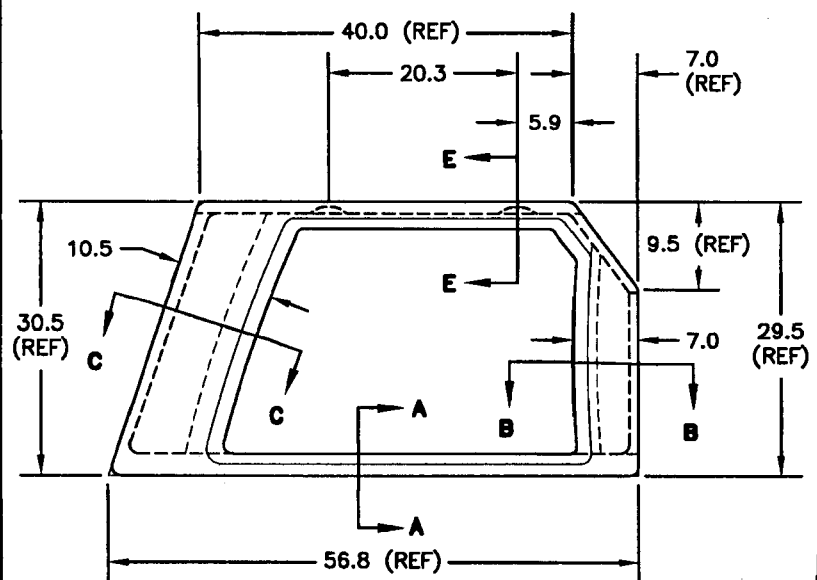


DETAIL F

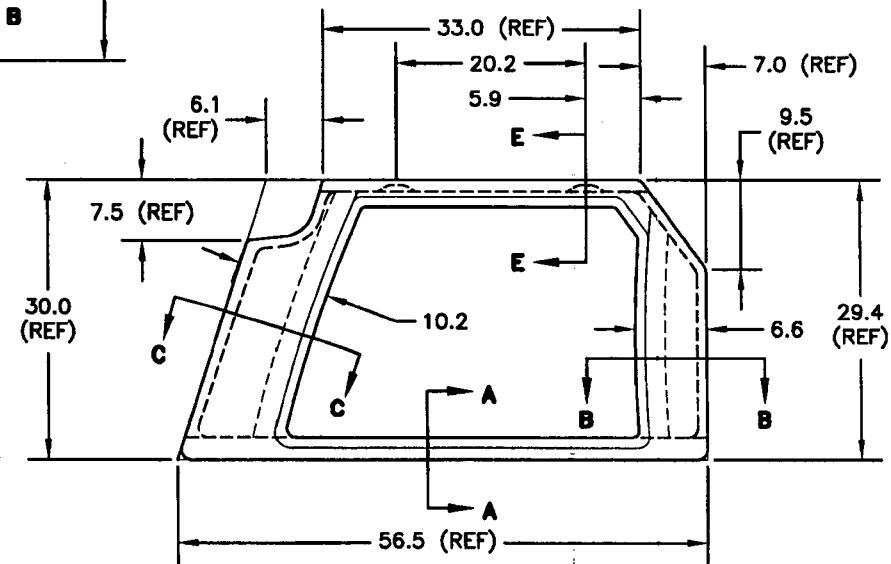
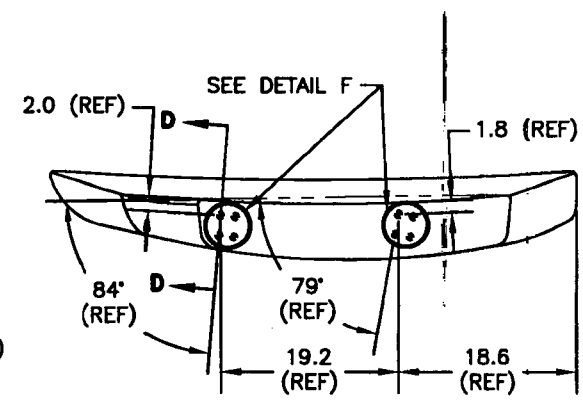
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



W/D
53185



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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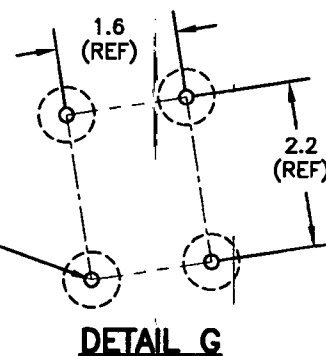
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DART

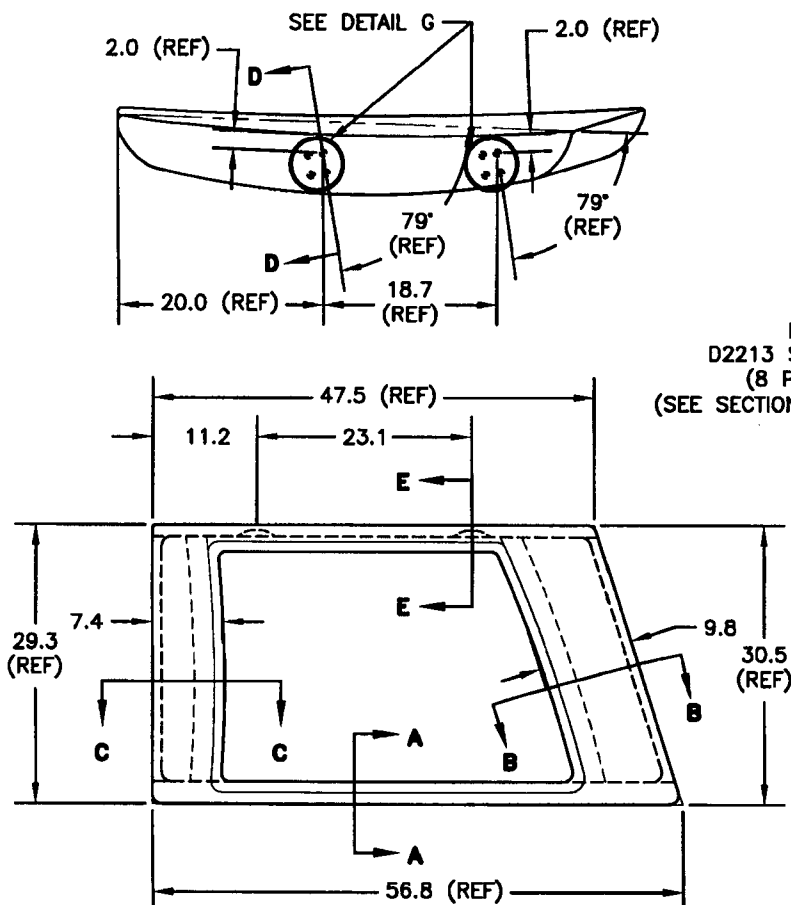
RELEASED

07.04.01

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 3 OF 11
		SCALE	NTS	



INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-2M SPACEPOD BODY

D3186-2M NOTES:

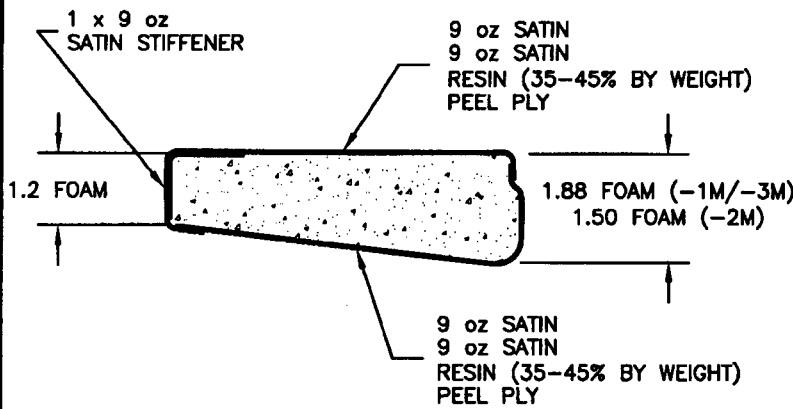
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

DART

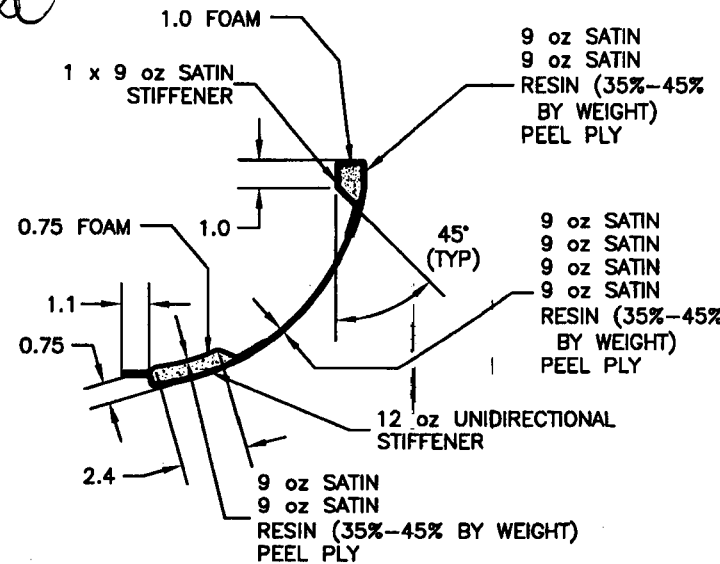
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CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	TITLE	D3188	REV. E
				SHEET 4 OF 11
				SCALE
				NTS

RELEASED
07.04.01

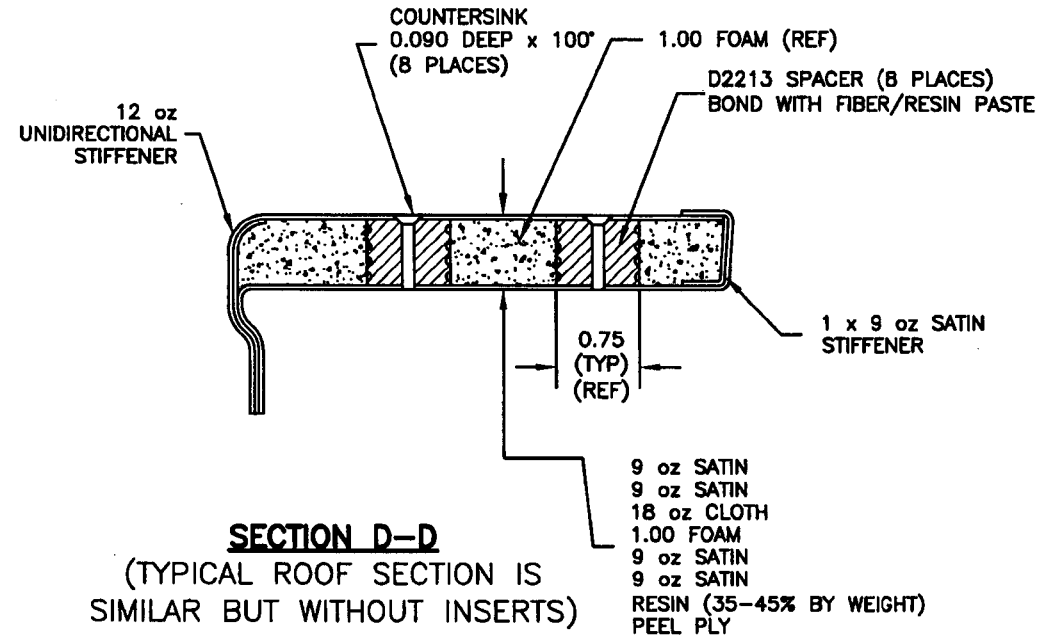
who ybba 53185



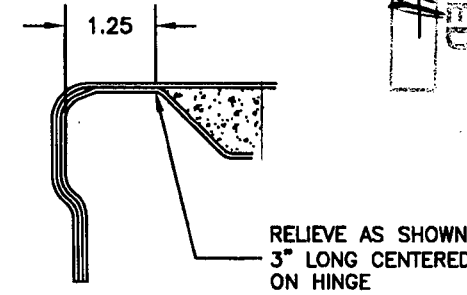
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

DART

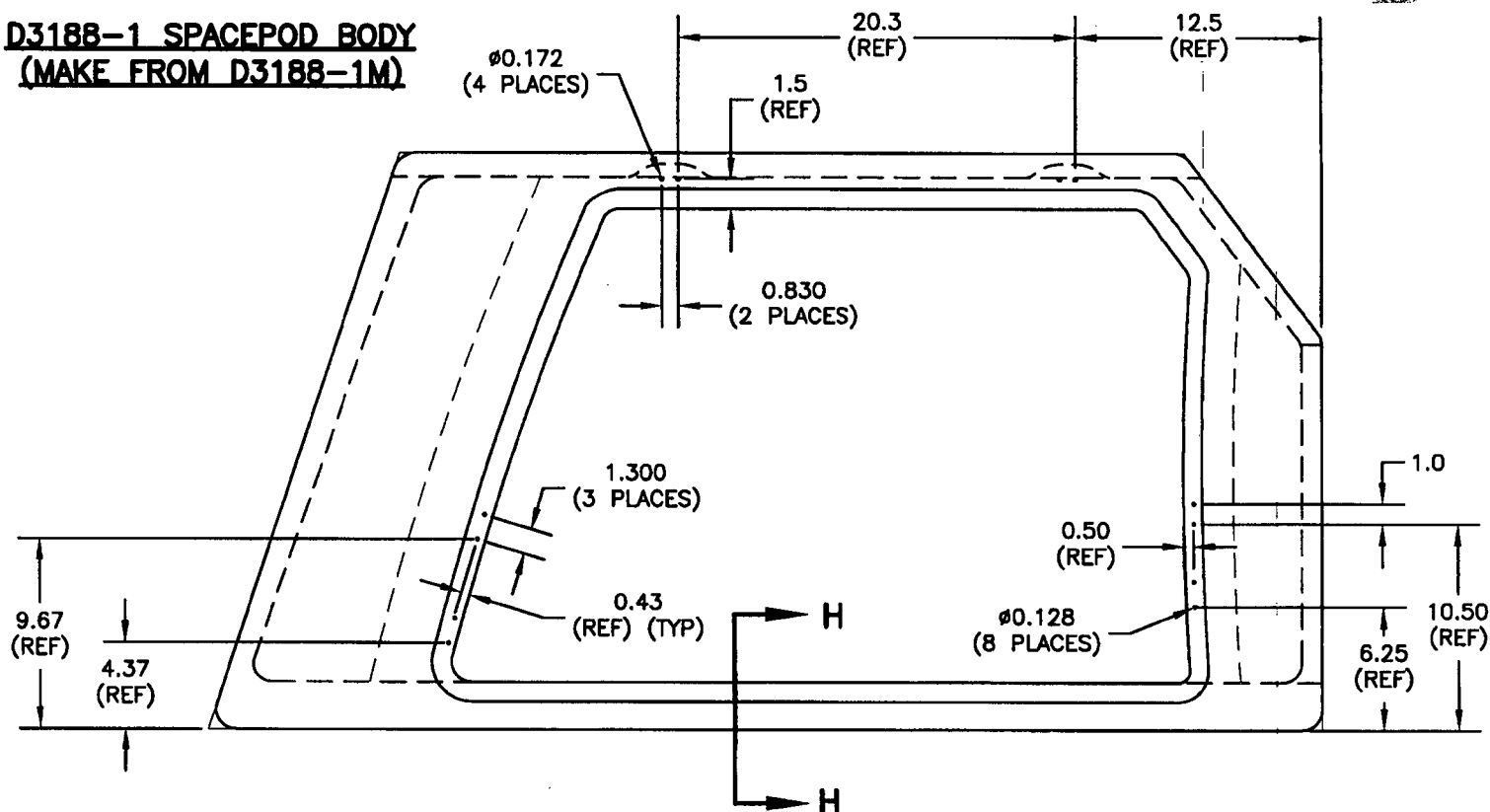
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CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET 5 OF 11	SCALE	NTS

RELEASED

07.04.01

w/o ~~4/18/85~~ 5385

D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)



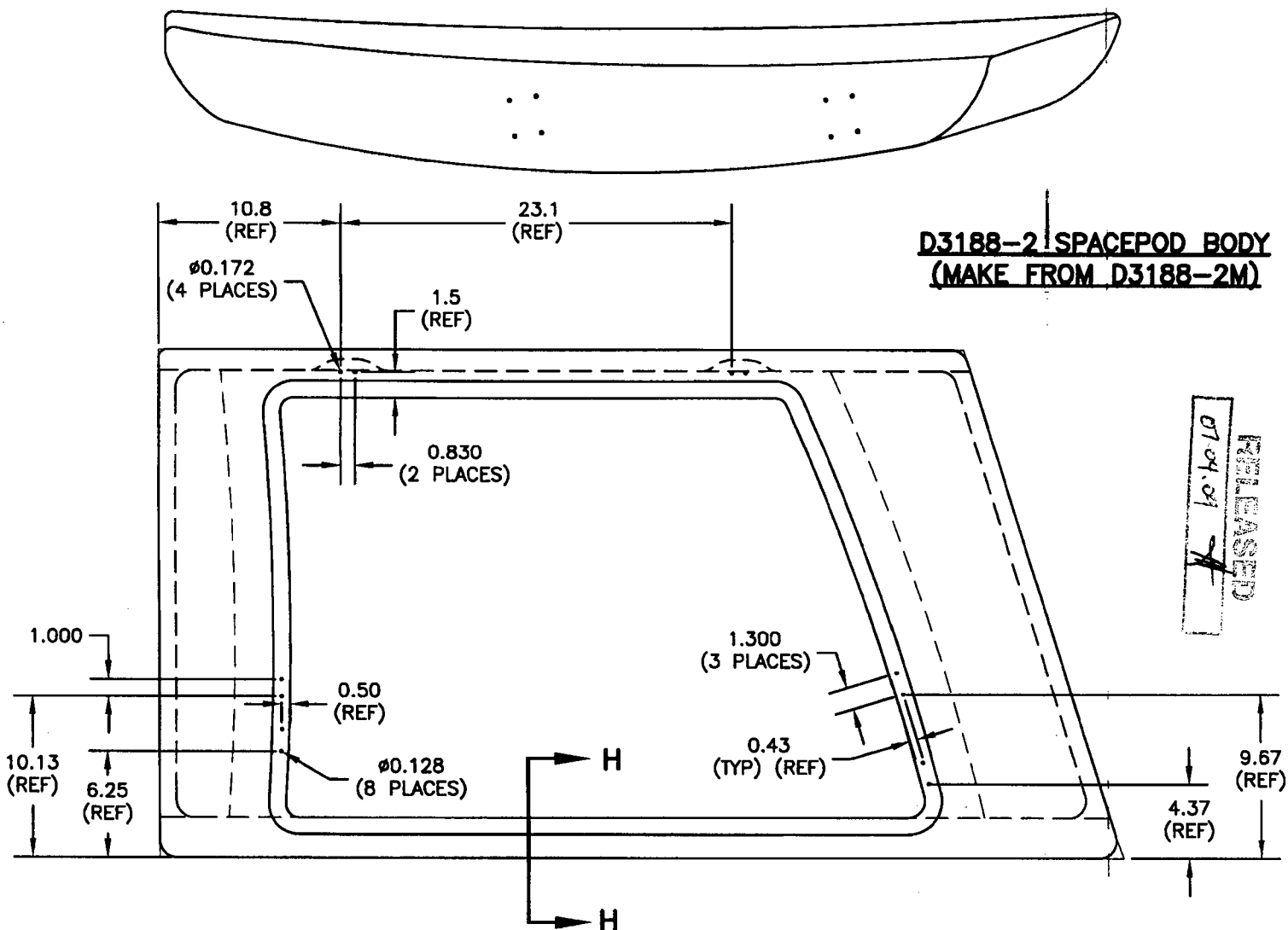
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DART

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E SHEET 6 OF 11
CHECKED	CE	APPROVED	[Signature]		
DATE	07.04.02	TITLE	SPACEPOD BODY		
		DRAWING NO.	D3188		
				SCALE	NTS

DECLASSIFIED
07-04-09



D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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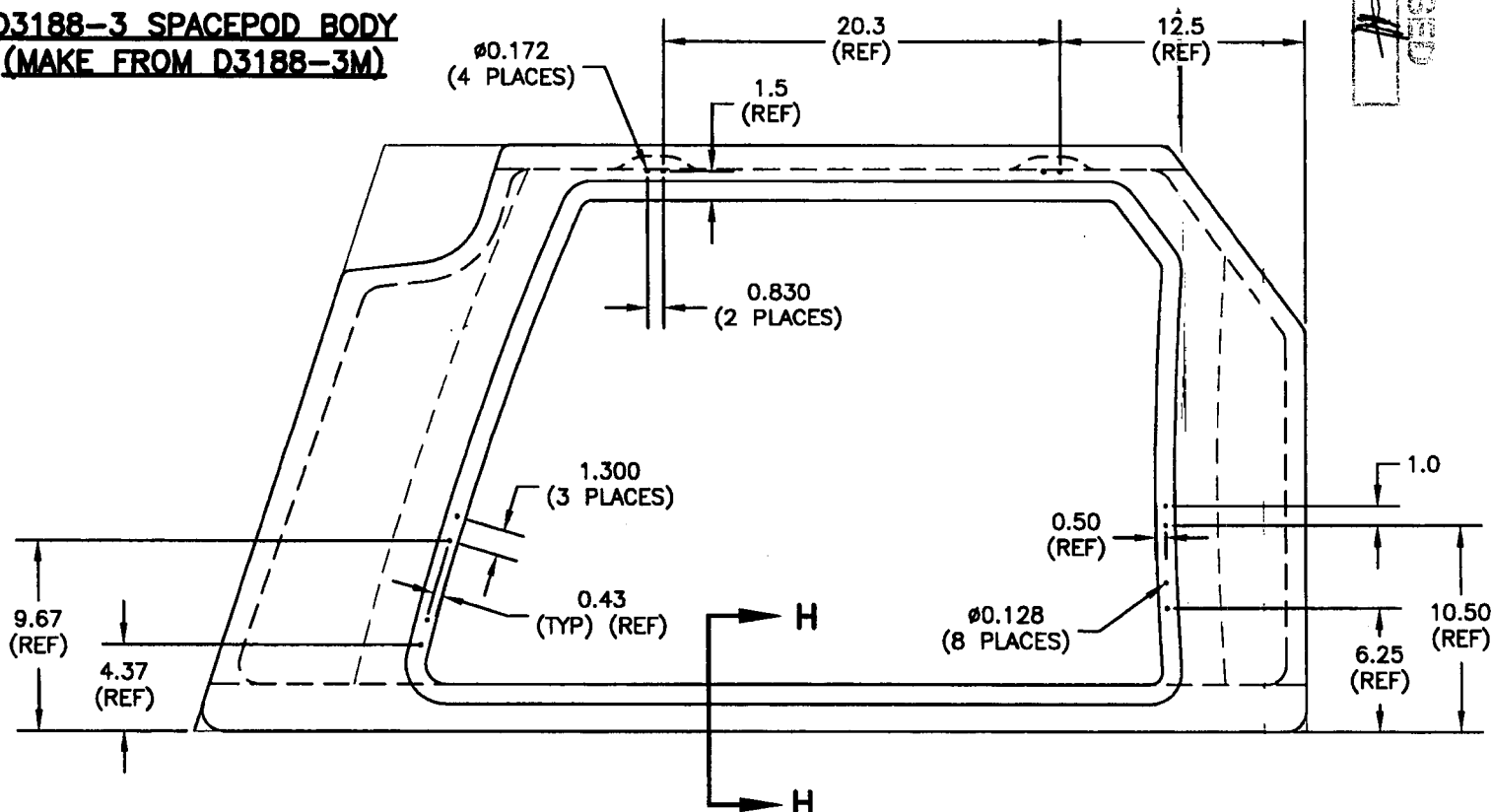
DART

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JB	C.B.	HAMKESBURY, ONTARIO, CANADA		
CHECKED <i>Le</i>	APPROVED <i>CB</i>	DRAWING NO.	REV. E	
		D3188	SHEET 7 OF 11	
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS	

RELEASED
07.04.01
CB

no 53185

**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

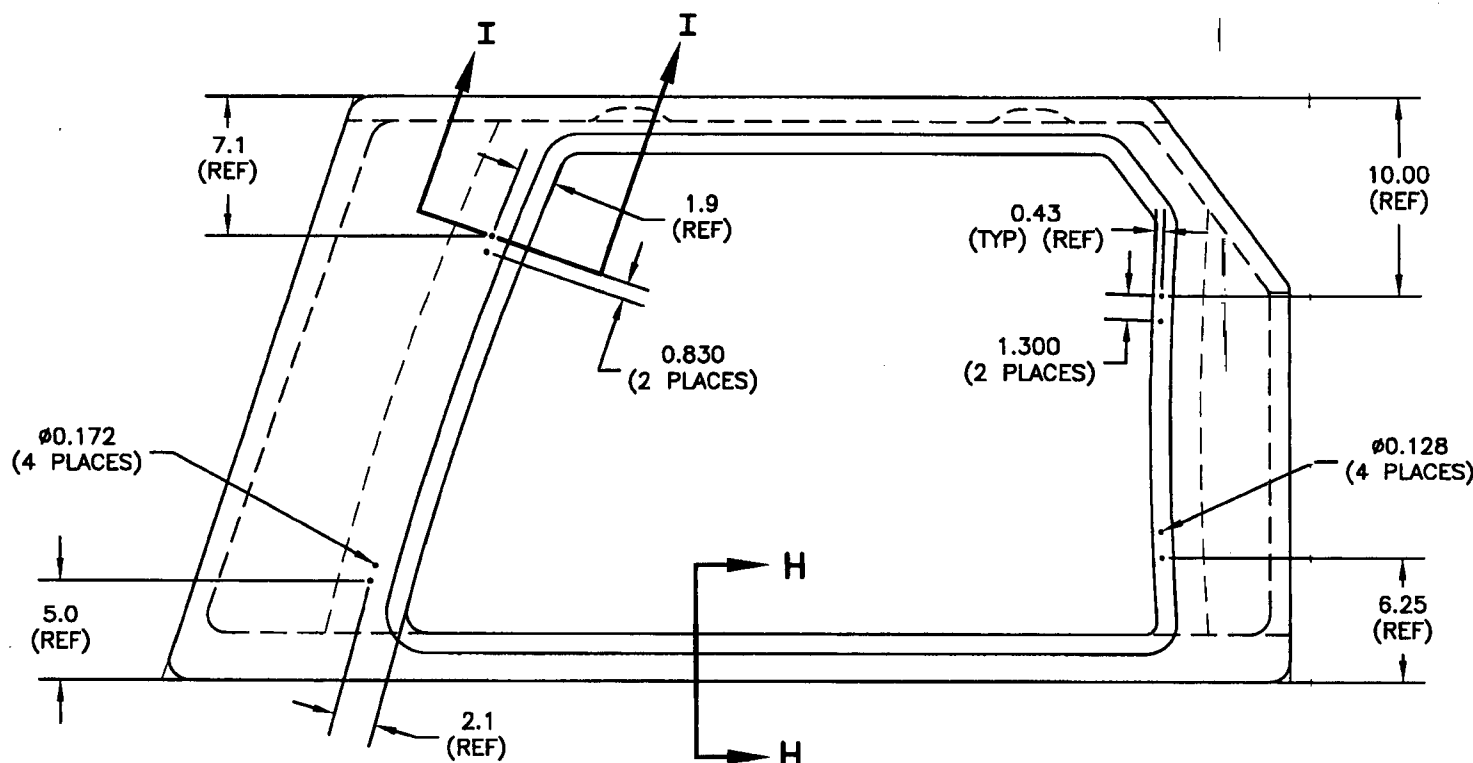
DART

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	CE	APPROVED	CB	DRAWING NO. D3188	SHEET 8 OF 11
DATE	07.04.02	TITLE	SPACEPOD BODY	SCALE	NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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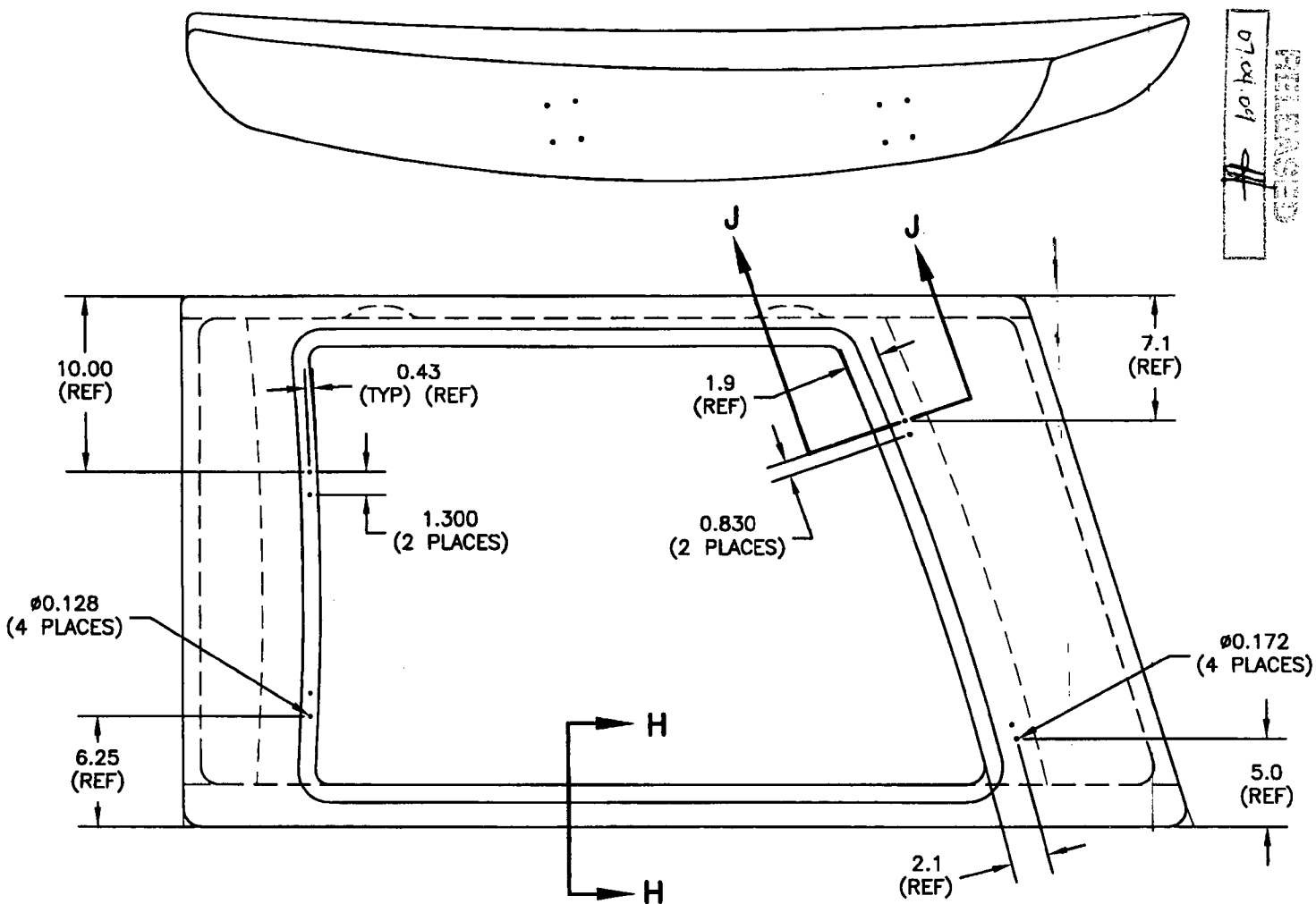
DART

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 9 OF 11
		SCALE	NTS	

RELEASED
07.04.02

w/o ~~4188~~ 53185

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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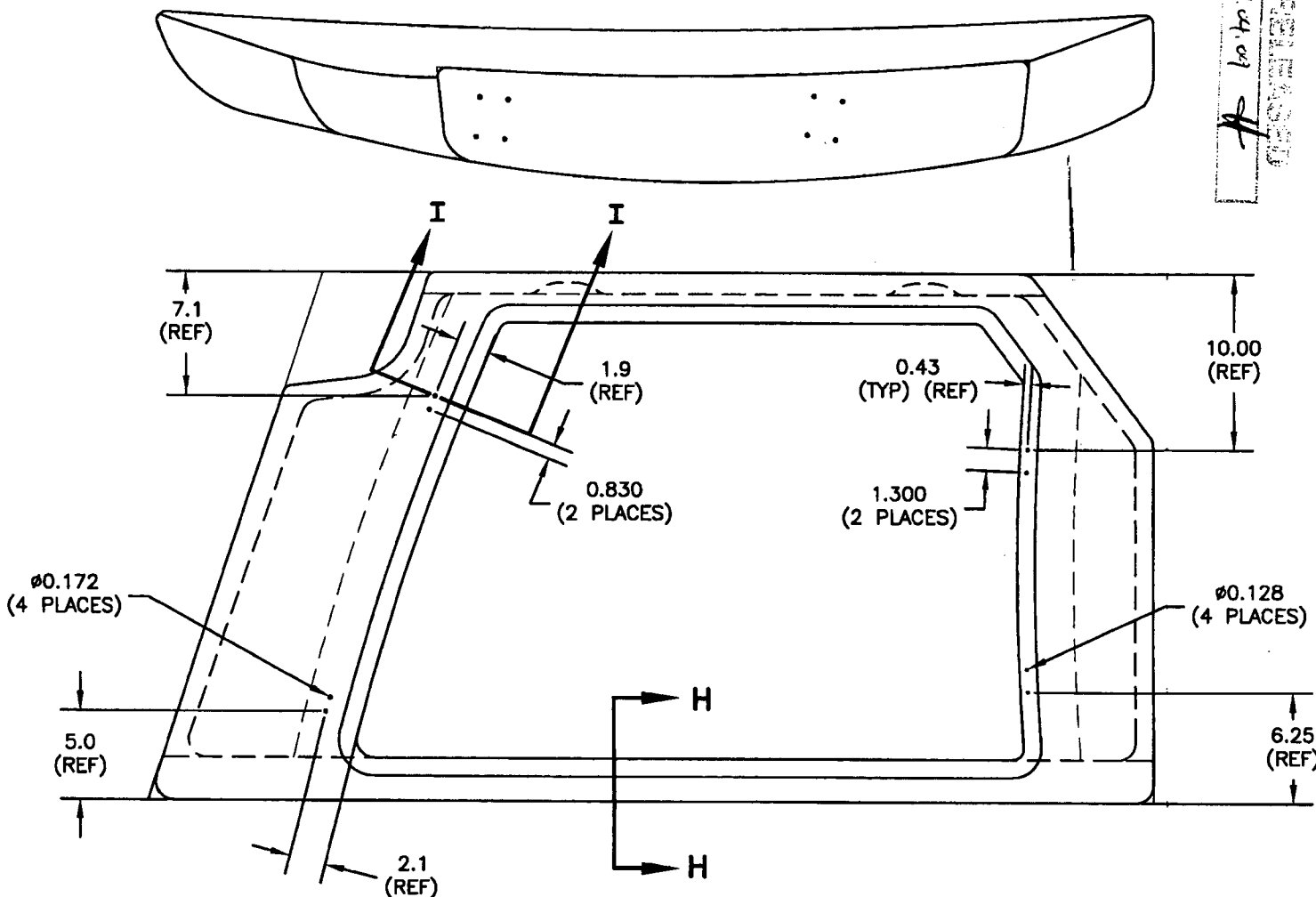
DART

DESIGN	JB	DRAWN BY	C.B.	DART AEROSPACE LTD
CHECKED	CE	APPROVED	#	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 10 OF 11
		SCALE	NIS	

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)

W/O ~~416188~~ 53185

07.04.02
#



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS



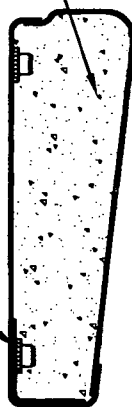
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
01.04.09 **[Signature]**

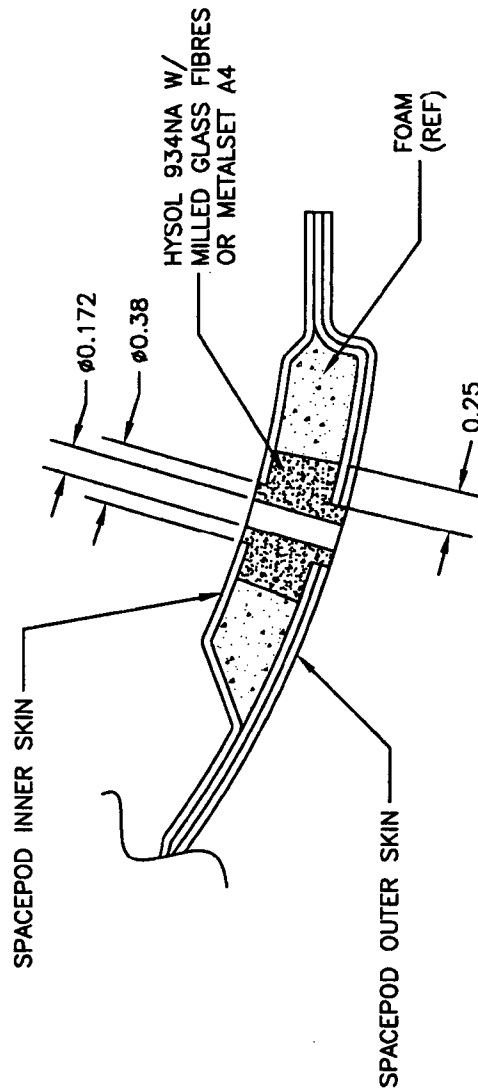
W/O 40180
5385

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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IIN-D350-600

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
✓ 1				X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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